

Batch Proj

Work Order ID 55477

January 19, 2010 1:28:55 PM



Page 1

Item ID: D2521

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw 205

Start Date: 1/19/10

Start Qty: 20.00



Cust Item ID:

Required Date: 1/25/10

Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

RF

Date: 10-1-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2521

Rev J

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2521 blank file

B 10-1-20

(18)

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2521 Identify as D2521
3-Deburr

10/01/23
10/01/22

18 0

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10/01/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55477

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Item ID: D2521

Accept

Revision ID:

Item Name: Bearpaw 205

Start Date: 1/19/10 Start Qty: 20.00

Required Date: 1/25/10 Req'd Qty: 20.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

SL 10/01/25

18

P 0 14.01/25 18

10/01/25

MF 10-1-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 55477



Parent Item: D2521

Parent Item Name: Bearpaw 205

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MUHMWB10		Purchased	No				sf	431.9957	147.3684			
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UHMW 1" Black



18 10-1-20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

400.248

112186

122.0164

113166

76.1264

113591

202.1052

113591

Main Warehouse

ST

31.7477

111354

31.7477

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 55477
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	260	✓			
B	0.90	0.96	925	✓			
C	0.27	0.330	310	✓			
D	0.470	0.530	490	✓			
E	21.740	21.760	21.750	✓			
F	0.72	0.780	750	✓			
G	0.35	0.410	382	✓			
H	11.490	11.570	11.500	✓			
I	3.41	3.47	3.440	✓			
J	11.790	11.810	11.800	✓			
K	9.47	9.53	9.500	✓			
L	7.190	7.210	7.200	✓			
M	6.910	6.970	6.940	✓			
N	44.47	44.530	44.500	✓			
O	6.590	6.650	6.620	✓			
P	0.940	0.980	950	✓			
Q	18.97	19.03	19.000	✓			
R	0.350	0.410	385	✓			
S	0.740	0.780	760	✓			
T	0.240	0.280	260	✓			
U	0.370	0.410	390	✓			
V	0.740	0.780	755	✓			
W	0.740	0.780	760	✓			

Measured by: mk	Audited by: JL	Prototype Approval:	N/A
Date: 10/01/22	Date: 10/01/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

DART

DESIGN	<i>#</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	APPROVED	<i>#</i>	DRAWING NO.	REV. J
				D2521	SHEET 1 OF 3
DATE	06.07.28			TITLE	SCALE
				205 BEARPAW	NTS
A	95.11.28	NEW ISSUE			
B	96.01.11	SHOW BENDING MOVE HOLES			
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING			
D	96.05.14	ADJUSTED BEAR PAW THICKNESS			
E	96.12.18	43.500 WAS 46.750			
F	97.05.07	ADDED REAR POCKET, MOVED HOLES			
G	98.08.06	ADD C'BORE AND CHAMFER EDGES			
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.			
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES			
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE			

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35477

RELEASED

06 08.23 *#*

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DART

DESIGN

DRAWN BY

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

REV. J

D2521

SHEET 2 OF 3

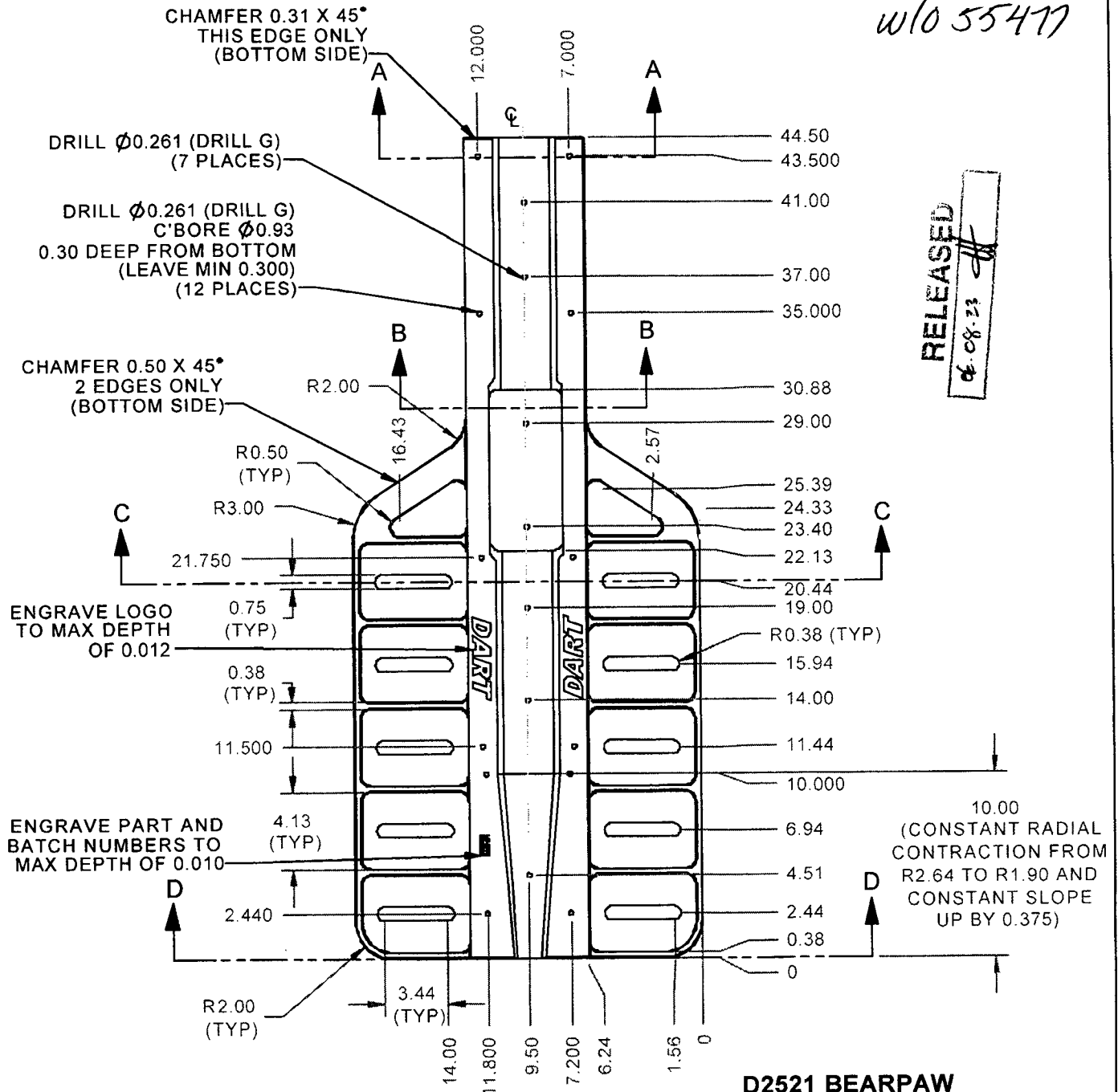
DATE

TITLE

SCALE

06.07.28**205 BEARPAW**

1:8

*w/o 55477***RELEASED**
6-08-23**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT \varnothing

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